

Work Order ID 59968

Tuesday, June 22, 2010 9:59:47 AM

Page 1

Item ID: D350-591-312

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step, Long RH

Start Date: 6/22/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 7/20/2010 Req'd Qty: 10.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date: 10-6-22 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	DOCUMENT CONTROL	0.00							
DC	Memo	0.00							
Document Control	Photocopy bluefile and type labels as per PPP D350-591-312 CHG001								
	2 Lead Put red holes only								
110	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	1-Bevel end for welding FWD ONLY								
	2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272								
	A/R Aluminum Rod M112860								
	3-Grind End Plate flush M114242								

8/10/2011

10-07-06

10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

(10) 10.07.06

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/07/06

(10)
RH

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

K 10.07.12

10

of

W/O:		WORK ORDER CHANGES						
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Sequence ID/
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DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

SAD 10-07-13

(10)

Memo

0.00

180



Large Fab

Large Fab

Large Fab

0.00

0.00

Memo

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R ☐ Aluminum Rod ☒ 1112860

6-Grind End Plate flush

7-Install last rivet as per Dwg.

10 07 13

10

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Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				⑩	10.07.13		
200 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				+10 RH			
210 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				10RA	BK 10-7-B.		

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Customer:

Reference:

Run

Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

M 114841

1045

320°

11:15

10

BR 10-7-14

230

Wing Walk as per dwg QSI005 4.4 Batch

0.00



HandFinish

Memo

0.00

Hand Finishing

el 10/02/15

10

φ

240

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8 10/02/15

(410)
AM

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Reference:

Run

Start



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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250 	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
260 	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									
270 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-312 Location: _____								

10-7-A

SL (102)

710

RH

10-7-A

SL (102)

W/O:		WORK ORDER CHANGES						
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF
10-7-20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Picklist Print

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Page 1

Work Order ID: 59968

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 6/22/2010

Required Date: 7/20/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
 IPP Rev:B 07-06-09 Added D3572-1 JLM
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:cC IPP Rev:D
 fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3067-1 End Plate		Manufactured	No			110	Each	3.0000	1	10			
<div> <div>Location</div> <div>WA 359596</div> <div>57926</div> </div> <div> <div>Loc Qty</div> <div>3</div> <div>3</div> </div> <div> <div>Loc Code</div> </div>													
D3272-1 Step		Manufactured	No			110	Each	10.0000	1	10			
<div> <div>Location</div> <div>WA 358544</div> <div>59952</div> <div>355244</div> </div> <div> <div>Loc Qty</div> <div>10</div> <div>10</div> </div> <div> <div>Loc Code</div> </div>													
D3065-041 Step Leg Assembly Hi		Manufactured	No			180	Each	14.0000	1	10			
<div> <div>Location</div> <div>WA 58160</div> <div>58536</div> </div> <div> <div>Loc Qty</div> <div>14</div> <div>1</div> <div>13</div> </div> <div> <div>Loc Code</div> </div>													

10.07.12

10.06.24

359952 = 10

9

10.07.12

19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 6/22/2010

Required Date: 7/20/2010

Start Qty: 10.00

Required Qty: 10.00

D3066-1
Spacer
Manufactured No 180 Each 77.0000 2 20

Location	Loc Qty	Loc Code
WA 360194	77	
58540	77	

10-07-12

D3067-1
End Plate
Manufactured No 180 Each 3.0000 1 10

Location	Loc Qty	Loc Code
WA 359596	3	
57926	3	

10-07-12

D3219-1
Plate
Manufactured No 180 Each 113.0000 2 20

Location	Loc Qty	Loc Code
WA 58550	113	
59597	17	
	96	

10-07-12

MS20600-AD4W4
Rivets
Purchased No 180 Each 959.0000 16 160

Location	Loc Qty	Loc Code
ST321	959	
113368	62	
114181	11	
114718	2	
114935	884	

10-07-12

160

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 6/22/2010

Required Date: 7/20/2010

Start Qty: 10.00

Required Qty: 10.00

AN3-35A Purchased No 250 Each 17.0000



Bolt

Location Loc Qty Loc Code

ST353 17

114784 17

AN4-13A Purchased No 250 Each 478.0000



Bolt

Location Loc Qty Loc Code

ST357 478

114941 478

AN5-36A Purchased No 250 Each 269.0000



Bolt

Location Loc Qty Loc Code

ST341 269

114292 19

114784 50

114941 200

AN960JD10 NAS1149D0363J Purchased No 250 Each 0.0000



Washer

AN960JD416 NAS1149D0463J Purchased No 250 Each 6.0000



Washer

Location Loc Qty Loc Code

ST357 6

107939 6

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Start Date: 6/22/2010

Required Date: 7/20/2010

Start Qty: 10.00

Required Qty: 10.00

AN960JD516 NAS1149D0563J Purchased No

250 Each

0.0000

4

40



Washer

D2230-3

Manufactured No

250 Each

179.0000

4

40



Lug

Location

Loc Qty

Loc Code

ST476

179

55452

2

59115

17

59418

160

D2618

Manufactured No

250 Each

25.0000

2

20



Bushing

Location

Loc Qty

Loc Code

ST020

25

56892

1

57829

24

D2856-400

Manufactured No

250

f

182.7820

0.6

6



Abraison Strip

Location

Loc Qty

Loc Code

ST403

182.782

56626

182.782

D3235-1

Manufactured No

250

Each

103.0000

2

20



Mounting Lug

Location

Loc Qty

Loc Code

ST471

103

58717

43

59125

60

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Start Date: 6/22/2010

Required Date: 7/20/2010

Start Qty: 10.00

Required Qty: 10.00

D3278-041

Manufactured No

250

Each

60.0000

10



Support Assembly

Location

Loc Qty

Loc Code

ST471

60

59633

60

MS21042L3

Purchased

No

250

Each

3,085.000

20



Nut

Location

Loc Qty

Loc Code

ST300

3085

114523

585

114718

500

114784

2000

MS21042L4

Purchased

No

250

Each

3,046.000

80



Nut

Location

Loc Qty

Loc Code

ST300

3046

113422

68

114523

28

114718

950

114784

2000

MS21042L5

Purchased

No

250

Each

681.0000

20



Nut

Location

Loc Qty

Loc Code

ST139

500

114813

500

ST300

181

114449

181

Tuesday, June 22, 2010 9:59:52 AM

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Dart Aerospace Ltd

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DART

DESIGN <i>qp</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04 *[Signature]*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK CODE
NO. 59968

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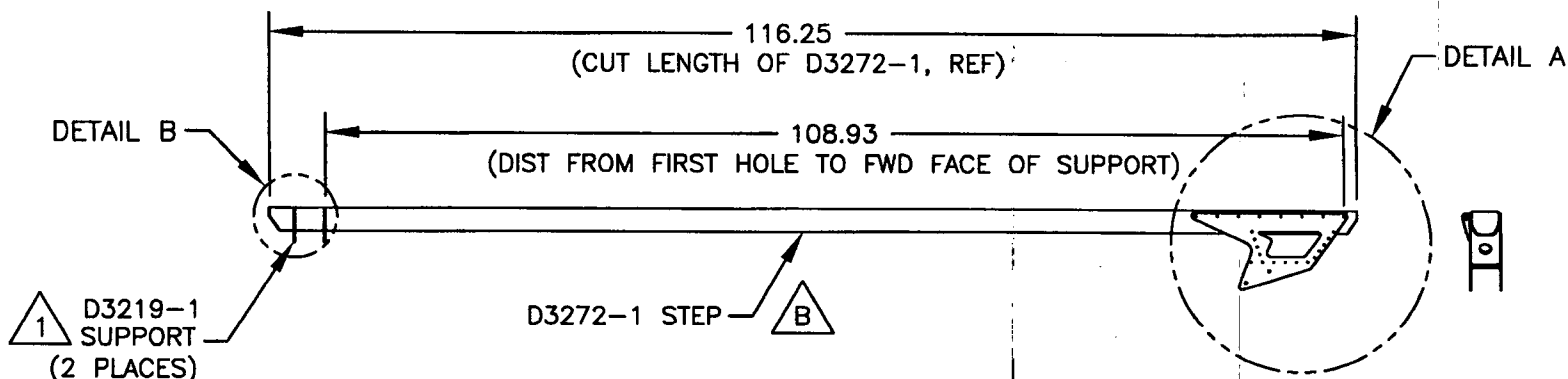
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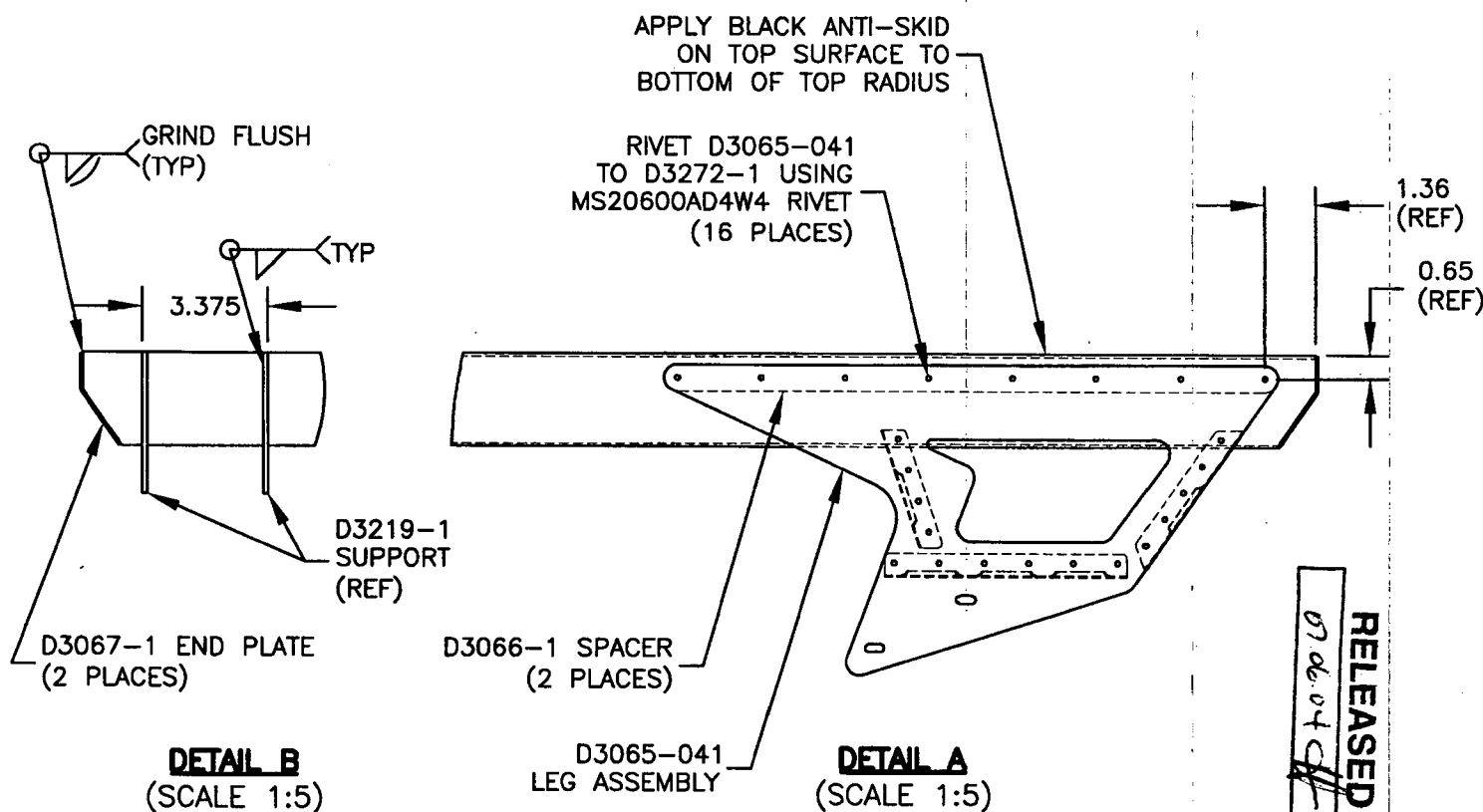
NOTE: Date & initial all entries

DART

DESIGN	AP	DRAWN BY	JB	DART AEROSPACE LTD
CHECKED	CE	APPROVED	JB	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	REV. B
		DRAWING NO.	D3272	SHEET 2 OF 3
		SCALE	1:20	



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

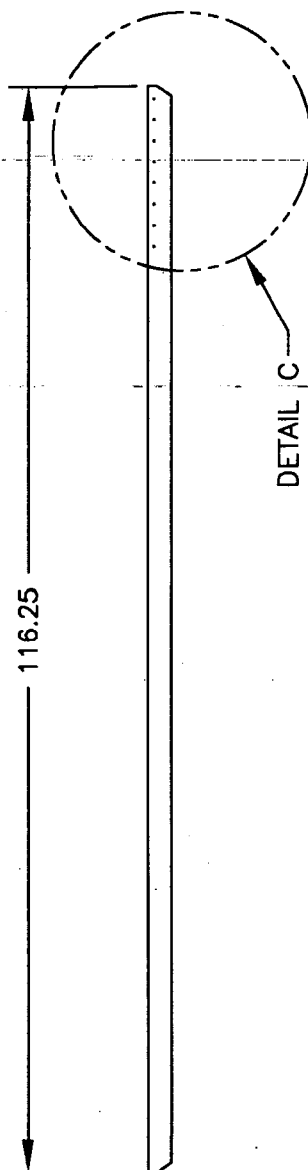
NOTE: Date & initial all entries

DART

DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20

RELEASED

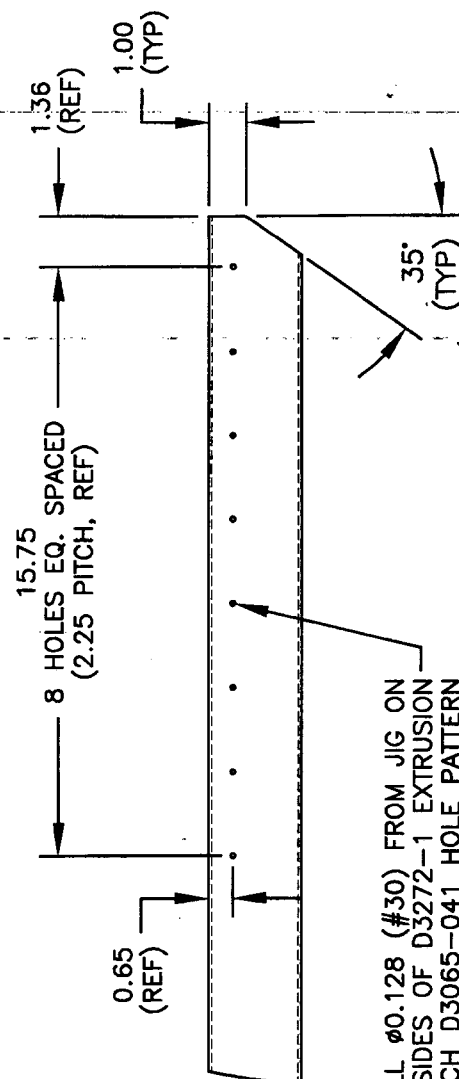
07.06.04 *H*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C

(SCALE 1:5)

wb 3006

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

Work Order ID 59968



Page 1

Tuesday, June 22, 2010 9:59:47 AM

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 6/22/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 7/20/2010 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *[Signature]*

Date: 10-6-27 Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3272	Rev B								
100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile and type labels as per PPP D350-591-312 CHG001								
110		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Bevel end for welding FWD ONLY								
	2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272								
	A/R Aluminum Rod <i>M112860</i>								
	<i>M114242</i>								
	3-Grind End Plate flush								

REFERENCE ONLY

10-07-06 10 *[Signature]*